

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave. St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020106**Date Inspected:** 27-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Yu Jiao (ABF)**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** BAY 14 OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Robert A. DeArmond was present during the time noted above and conducted observations relative to the work being performed.

OBG BAY 14

This QA Inspector observed the following work in progress:

FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "W" Line identified as SA7512 weld number(s) 227 and 228. Welder is identified as welder no. 06602. The welding variables recorded by ZPMC QC identified as Zhong Yang Gang appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM.

FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A "W" Line identified as SA7512 weld number(s) 231 and 262. Welder is identified as welder no. 037780. The welding variables recorded by ZPMC QC identified as Zhong Yang Gang appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM.

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FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A “W” Line identified as SA7512 weld number(s) 232 and 235. Welder is identified as welder no. 067611. The welding variables recorded by ZPMC QC identified as Zhong Yang Gang appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM.

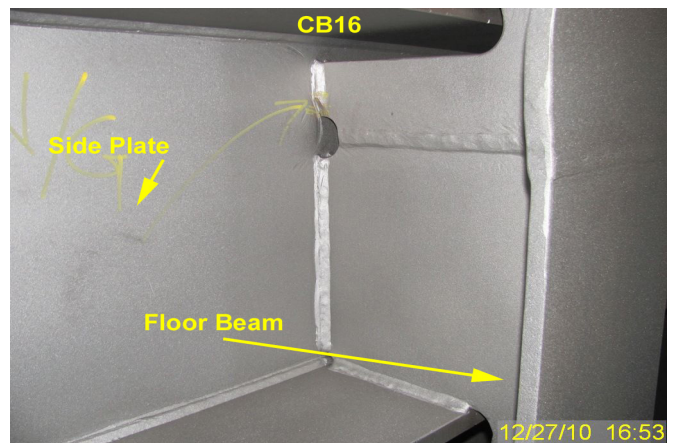
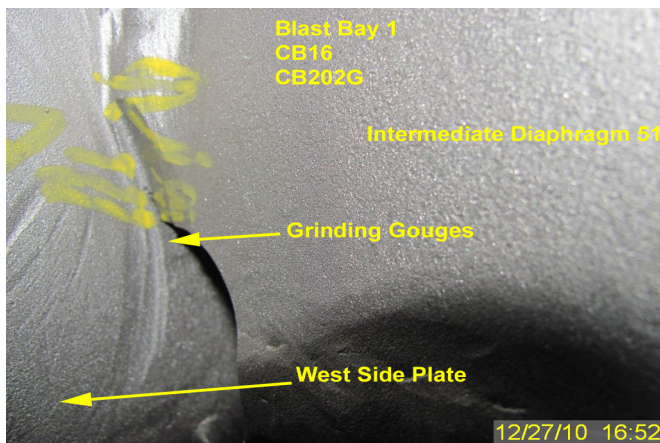
FCAW welding of complete joint penetration weld joint(s) located on Grillage Plate Sub-Assembly, Segment 13A “W” Line identified as SA7512 weld number(s) 236 and 237. Welder is identified as welder no. 067588. The welding variables recorded by ZPMC QC identified as Zhong Yang Gang appeared to comply with applicable WPS(s) WPS-B-P-2211-TC-U4b-FCM.

FCAW welding of fillet weld joint(s) located on 14W Segment 3020J-001 weld number(s) 015. Welder is identified as welder no. 045175. The welding variables recorded by ZPMC QC identified as Li Ping appeared to comply with applicable WPS(s) WPS-B-T-2133-ESAB

Blast Bay 1

This Caltrans QA Inspector and three other Caltrans QA inspectors performed a pre-blast visual inspection of the interior surface and internal components, CB16 Cross Beam assembly. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

As mentioned above between QA and QC concerning this project

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By:	DeArmond,Robert
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Quality Assurance Inspector

Reviewed By:	Riley,Ken
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QA Reviewer
